

Rush

# Work Order ID 70871



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Thursday, June 16, 2011 12:49:13 PM

Item ID: D3017-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3017

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3017

Dwg Rev: B

Prog Rev: B

2-Deburr

B11-6-16

18

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-16

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Item ID: D3017-7	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Lug					
Start Date: 6/16/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 6/20/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
130  Brake NC Brake NC	NC BRAKE  Memo 1-Deburr 2-Form as per Dwg D3017 using DT8598	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							

SB 11/26/11

SB 11/26/12

SB 11/26/12

118

10

118

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Item ID: D3017-7

Accept

Revision ID:

Item Name: Lug

Start Date: 6/16/2011 Start Qty: 6.00

Required Date: 6/20/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and bag with light oil (Vactra oil #2), then Stock Location: <u>W/A 030</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

EL 11-06-2111/6/2111-06-21

# Picklist Print

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Work Order ID: 70871



Parent Item: D3017-7



Parent Item Name: Lug

Start Date: 6/16/2011

Required Date: 6/20/2011

Start Qty: 6.00

Required Qty: 6.00

**Comments:**

IPP: ☐ B ☐ 03.05.09 ☐ Reformat ☐ KJ/RF ☐

IPP Rev: C 08-04-11 now made on water jet DD verified

by: EC IPP RevB: as per revB DD verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NS.049

Purchased

No

100

sf

11.9000

0.102

0.644211

2



BI-6-16

4130 Sheet .049

Location

Loc Qty

Loc Code

MAT020

11.9

11612

9.4

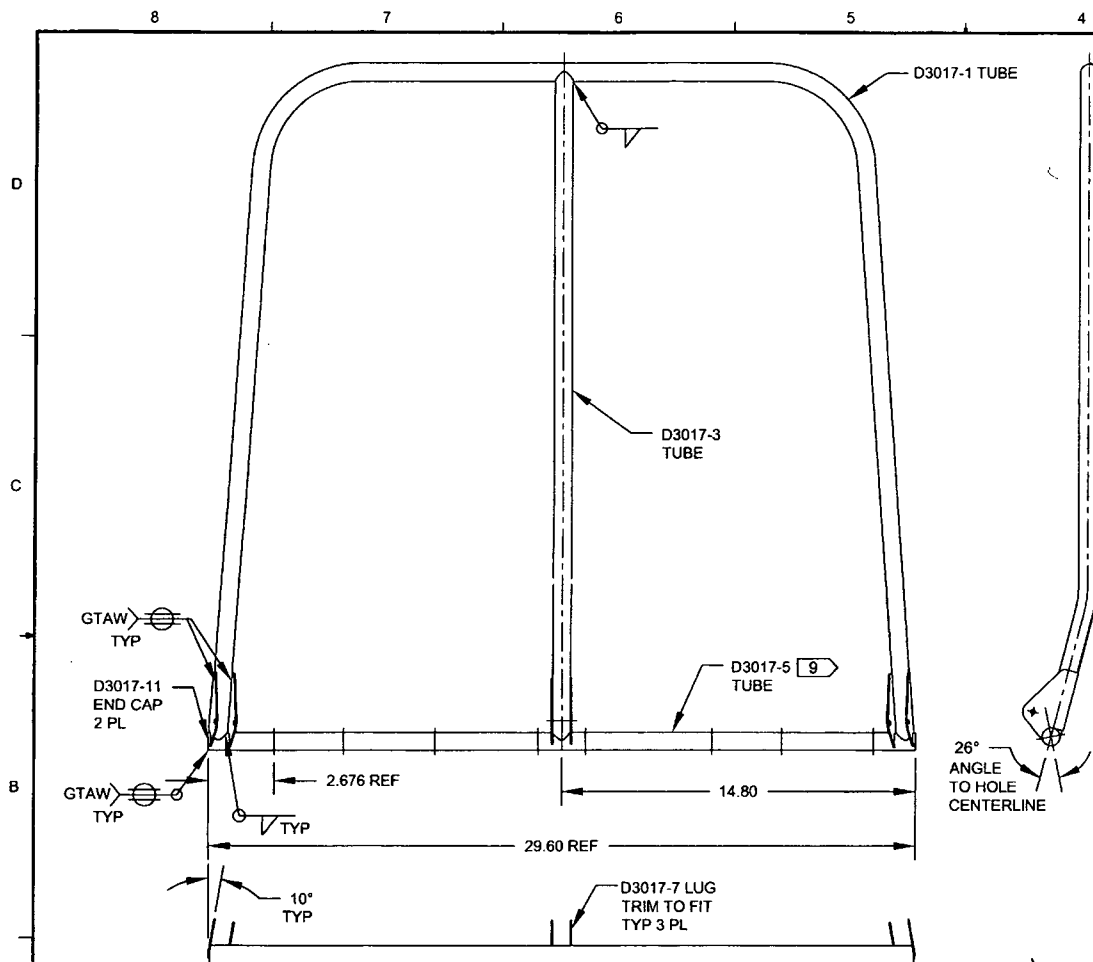
16443

2.5

16443

(18)





ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

### D3017-041 BACK FRAME ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

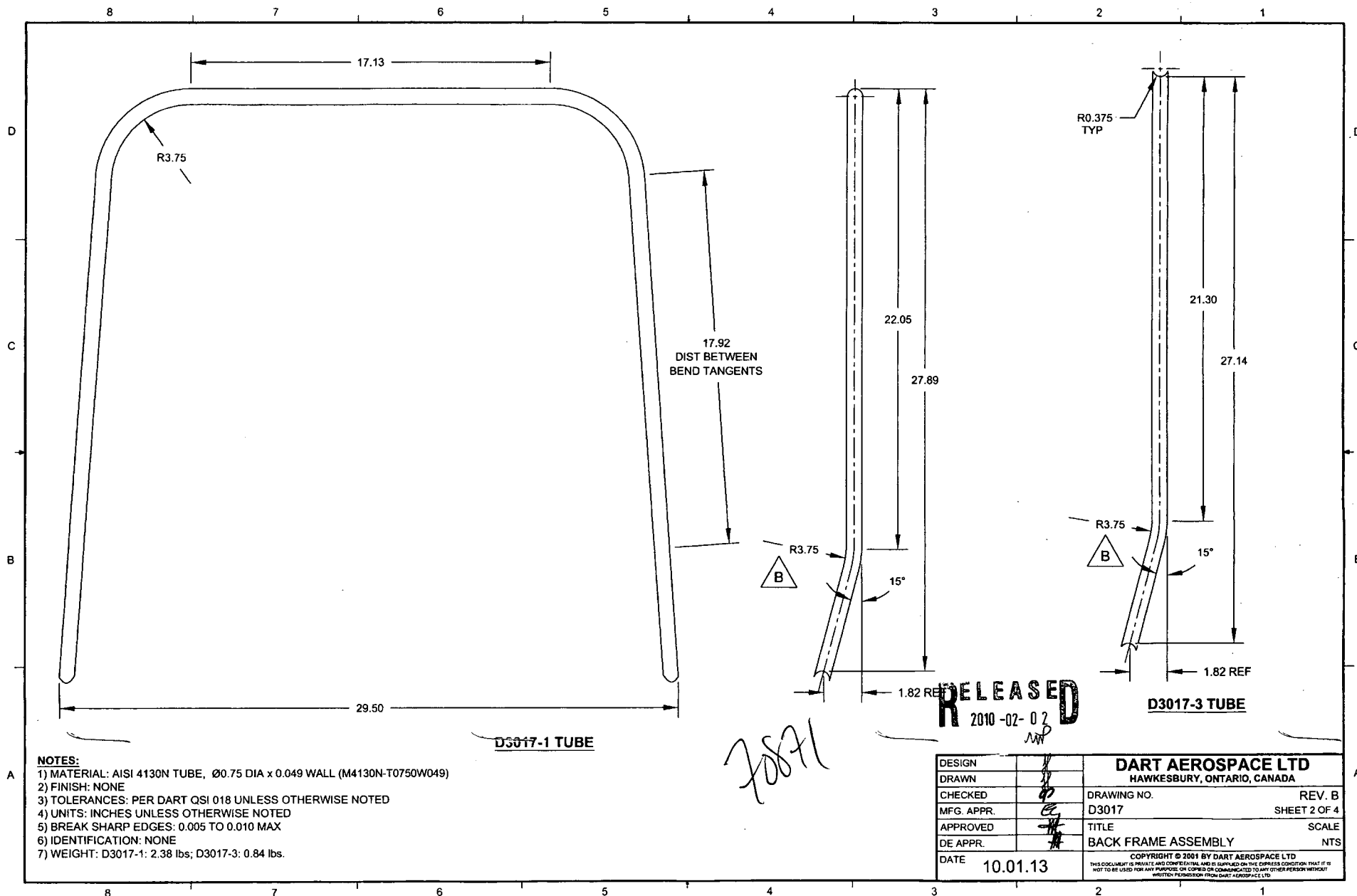
RELEASED  
R 2010-02-02

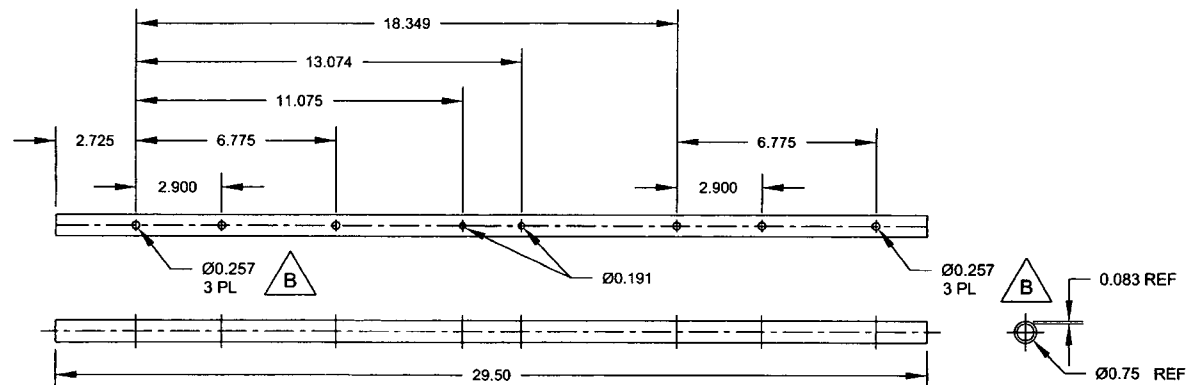
B	REFORMAT DWG. -5 TUBE WALL THKNS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D3017 SHEET 1 OF 4  
TITLE SCALE  
BACK FRAME ASSEMBLY NTS

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**D3017-5 TUBE**

**RELEASED**  
2010-02-02

**NOTES:**

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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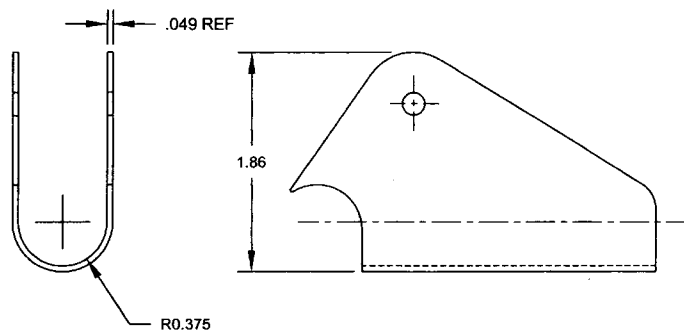
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D

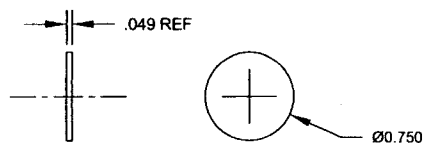
C

B

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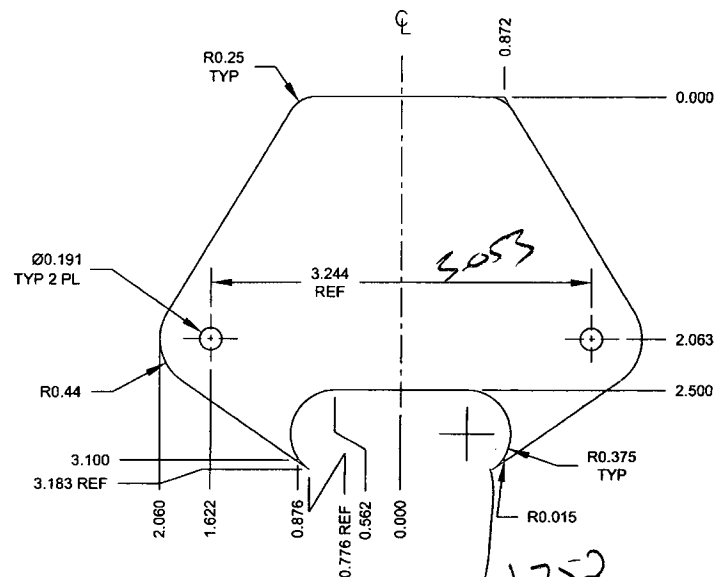
**D3017-7 LUG**  
BENDING DETAIL  
MAKE FROM D3017-7F



**D3017-11 END CAP**

**NOTES:**

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.



**D3017-7F FLAT PATTERN**  
PART IS SYMMETRIC  
ABOUT CENTERLINE

**RELEASED**  
2010-02-02

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8 7 6 5 4 3 2 1